

## CLAIMS

1                   1. A method of edge glueing, comprising the steps of  
2                   expanding a product web; transporting the expanded product web at least at  
3                   its edges in a predetermined distance from a spraying nozzle; and spraying  
4                   the expanded web with a glue, said spraying being performed by applying  
5                   the glue in a spin spraying process.

2                   2. A method as defined in claim 1; and further comprising  
3                   holding the product web under a longitudinal tensioning.

1                   3. A method as defined in claim 1, wherein said spraying with  
2                   glue includes using the glue composed of a solvent-containing product on  
3                   the basis of water.



1                    4. A method as defined in claim 3, wherein the product is  
2                    selected from the group consisted from a synthetic plastic dispersion and a  
3                    synthetic plastic solution.

1                    5. A method as defined in claim 1; and further comprising the  
2                    step of heating the glue before spraying to a temperature of 20-80°C.

1                    6. A method as defined in claim 1; and further comprising the  
2                    steps of measuring a quantity of the applied glue; and regulating the quantity  
3                    by varying the pressure of a substance applied by the spin spraying nozzle.

1                    7. A method as defined in claim 6, wherein said regulating  
2                    includes regulating by varying the pressure of the glue supplied by the spin  
3                    spraying nozzle.

1                   8. A method as defined in claim 6, wherein said regulating  
2 includes varying the pressure of an air supplied through the spin spraying  
3 nozzle.

1                   9. An arrangement comprising a tensioning aggregate; a  
2 device for edge glueing, said tensioning aggregate including a region in  
3 which product web is expanded on its edges and smoothed, said device for  
4 edge glueing including a spin spraying nozzle which is adapted to be  
5 arranged at a predetermined distance from the product web.

6                   10. An arrangement as defined in claim 9, wherein said spin  
7 spraying nozzle is arranged at a predetermined distance from the edges of  
8 the product web.  
9

1                   11. An arrangement as defined in claim 9, wherein said spin  
2 spraying nozzle is arranged at a predetermined distance from the sensor of  
3 the product web.

1                   12. An arrangement as defined in claim 9; and further  
2                   comprising a tensioning chain; an inlet device provided with pulling means,  
3                   expanding means and mounting means for mounting the edges of the  
4                   product web on said tensioning chain and located one after the other, so that  
5                   in the region of said pulling means and said mounting means the product  
6                   web is expanded and smoothed, said spin spraying nozzle being located in  
7                   said region at a height or behind said expanding means in front of said  
8                   mounting means, said mounting means being provided with openings for  
9                   glue tracks.

10                   13. An arrangement as defined in claim 9; and further  
11                   comprising an inlet device; and a tensioning chain, said device for edge  
12                   glueing being arranged behind said inlet device on said tensioning chain;  
13                   means for loosening the product web from said tensioning chain and  
14                   smoothing the product web located on the edges above the product web and  
15                   extending outwardly beyond the plane of the product web, said spin spraying  
16                   nozzle being arranged on said means; and mounting means provided directly  
17                   behind said means and having openings for a glue track for another  
18                   mounting of the product web on the tensioning chain.

1                   14. An arrangement as defined in claim 13, wherein the means  
2                   have a pressing roller, said pressing roller being vertically displaceable while  
3                   said mounting means being horizontally displaceable.

1                   15. An arrangement as defined in claim 14, wherein said  
2                   pressing roller is formed as a negative pressing roller.

1                   16. An arrangement as defined in claim 9; and further  
2                   comprising an inlet device; a tensioning chain, said device for edge glueing  
3                   being located behind said inlet device on said tensioning chain with a needle  
4                   box; and means for releasing the product web from the tensioning chain and  
5                   for clamping the product web, and holding means.

